

Work Order ID 57752

April 14, 2010 11:38:25 AM



Page 1

Item ID: D3163-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 4/14/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3163

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3163

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

6

1316-63

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1316-63

(S)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8106603

(+5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 57752

April 14, 2010 11:38:25 AM



Page 2

Item ID: D3163-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 4/14/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

wla 5

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

BB 10/06/07
XS

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Em-k w/06/07

5x

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 57752

April 14, 2010 11:38:26 AM



Page 3

Item ID: D3163-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 4/14/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 178

0.00



Packaging

Memo

0.00

Packaging

(5)

BD

10/06/09

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

mmf
10-6-9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:38:24 AM

Page 1

Work Order ID: 57752



Parent Item: D3163-1



Parent Item Name: Plate

Start Date: 4/14/10

Required Date: 4/19/10

Comments: IPP B05.10.25 Remove Powder Coat KJ/RF

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M2024T3S.032 | | Purchased | No | | | 100 | sf | 139.0000 | 8.0000 | | | |



2024-T3 .032 sheet



1310-6-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

139

105555

3

110778

4

111699

4

113189

128

113189

5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------------------|----------------|----------------------|
| D3065-5DART AEROSPACE LTD | | Work Order: 87752 |
| Description: Plate <i>10-2-03</i> | | Part Number: D3163-1 |
| Inspection Dwg: D3163 | Rev: <i>PE</i> | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

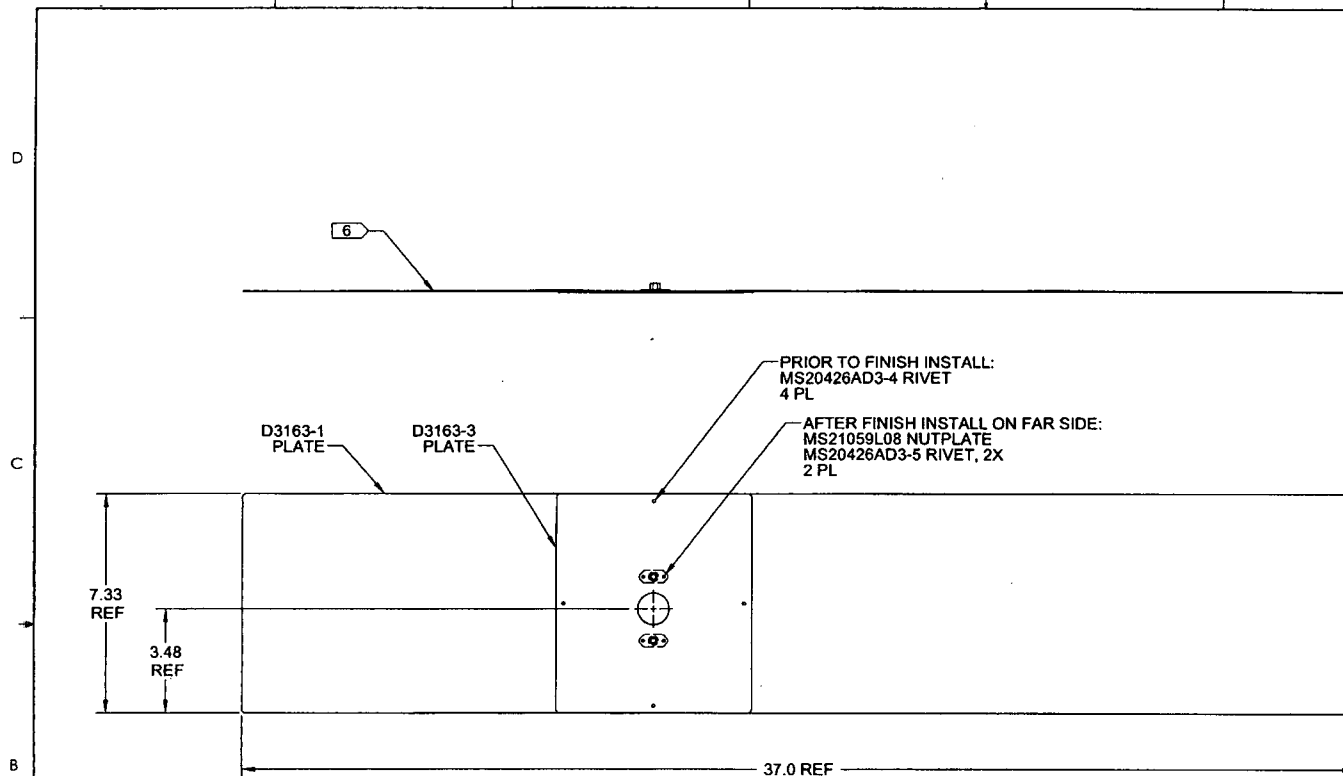
☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.004/-0.001 | .098 | ✓ | | | |
| Ø0.250 | +0.005/-0.001 | .252 | ✓ | | | |
| Ø1.050 | +0.012/-0.001 | 1.052 | ✓ | | | |
| 0.250 | +/-0.010 | .248 | ✓ | | | |
| 3.483 ✓ | +/-0.010 | 3.483 | ✓ | | | |
| 3.663 | +/-0.010 | ? | | | | |
| 7.33 | +/-0.030 | 7.332 | ✓ | | | |
| 13.69 | +/-0.030 | 13.69 | ✓ | | | |
| 37.00 | +/-0.030 | 37.000 | ✓ | | | |
| 3.000 | +/-0.010 | 3.001 | ✓ | | | |
| 0.344 | +/-0.010 | .344 | ✓ | | | |
| 1.063 | +/-0.010 | 1.060 | ✓ | | | |
| 0.032 | +/-0.010 | .031 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|------------------------|----------------------|---------------------|-----|
| Measured by: <i>IB</i> | Audited by: <i>S</i> | Prototype Approval: | N/A |
| Date: 10-6-3 | Date: 10/6/03 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------|-----------------------|--------------------|
| A | 09.10.01 | New | KJ <i>[Signature]</i> | <i>[Signature]</i> |

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|-------------|
| 1 | X | D3163-041 | PLATE |
| 2 | 1 | D3163-1 | PLATE |
| 3 | 1 | D3163-3 | PLATE |
| 4 | 4 | MS20426AD3-4 | RIVET |
| 5 | 4 | MS20426AD3-5 | RIVET |
| 6 | 2 | MS21059L08 | NUTPLATE |



D3163-041 PLATE

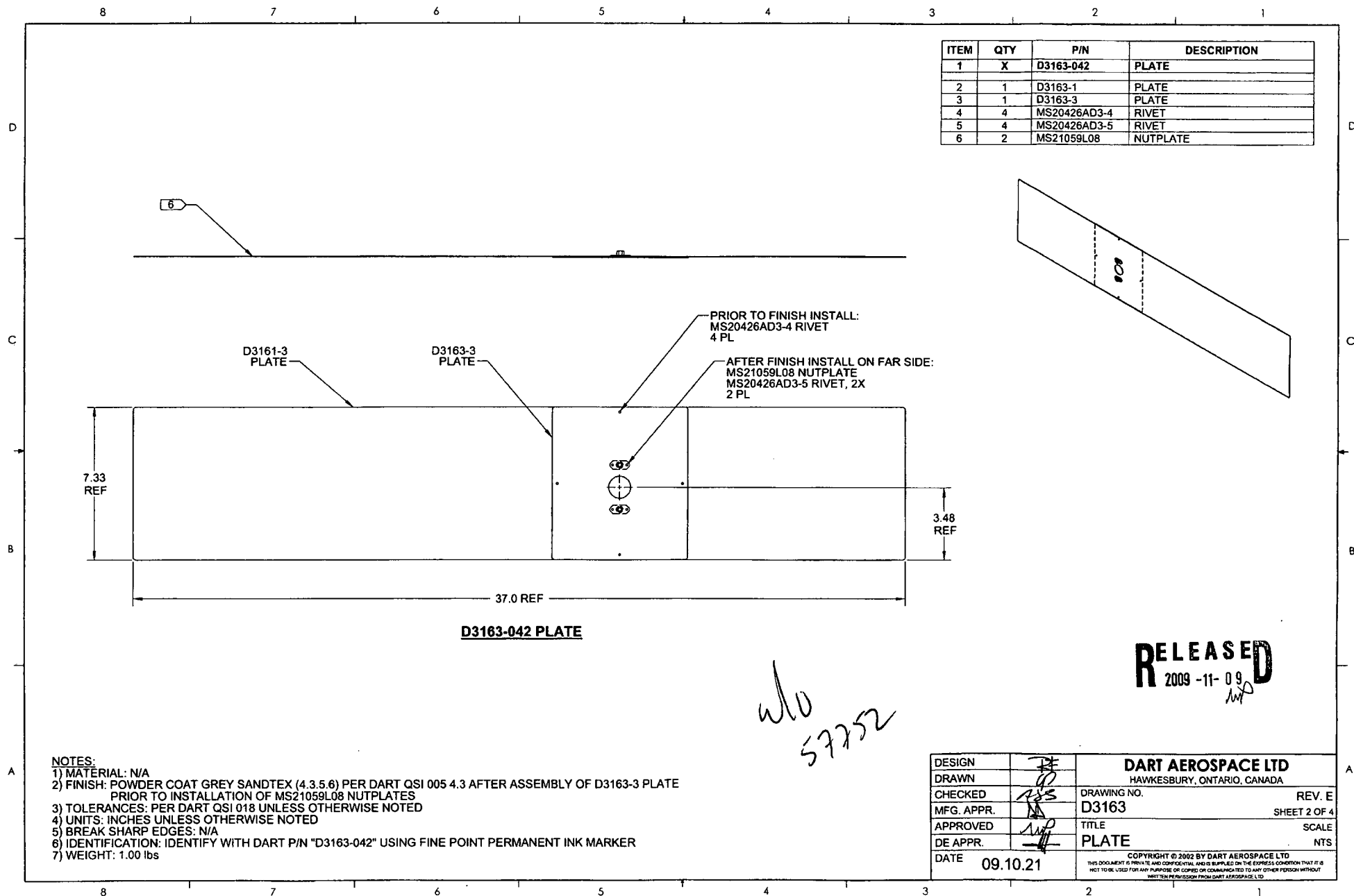
RELEASED
2009-11-09
mp

wb
57752

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE
PRIOR TO INSTALLATION OF MS21059L08 NUTPLATES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.00 lbs

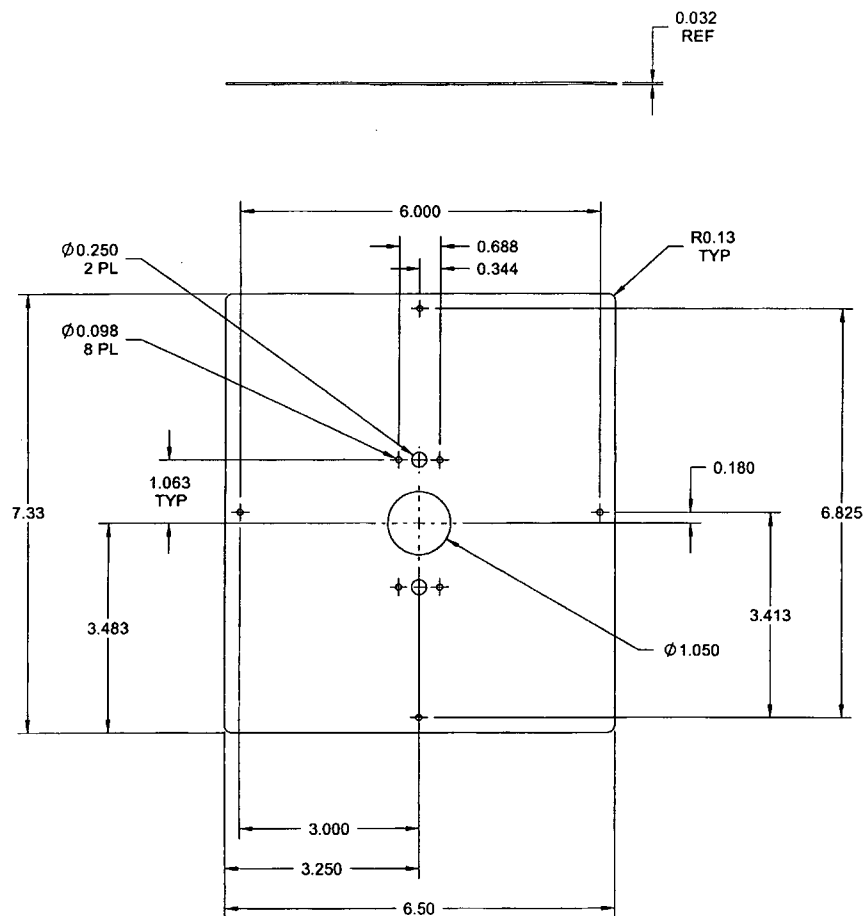
| | | | |
|------------|---|--|--------------|
| E | REDRAW, 13.89 WAS 12.81 (TYPO, ZN B6-3), NCR 09-095 | CP | 09.10.21 |
| D | ADD 4 RIVETS, RMV ADHESIVE | CB | 06.08.26 |
| C | Ø 1.050 WAS Ø 1.000 | RF | 05.11.22 |
| B | 7.33 WAS 7.20, RMV PERIMETER HOLES | RF | 04.10.06 |
| A | NEW ISSUE | RF | 02.04.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>JE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3163 TITLE PLATE COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DRAWN | <i>JS</i> | | |
| CHECKED | <i>JS</i> | | |
| MFG. APPR. | <i>MP</i> | | |
| APPROVED | <i>MP</i> | | |
| DE APPR. | <i>MP</i> | REV. E | SHEET 1 OF 4 |
| DATE | 09.10.21 | SCALE | NTS |



| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|-------------|
| 1 | X | D3163-042 | PLATE |
| 2 | 1 | D3163-1 | PLATE |
| 3 | 1 | D3163-3 | PLATE |
| 4 | 4 | MS20426AD3-4 | RIVET |
| 5 | 4 | MS20426AD3-5 | RIVET |
| 6 | 2 | MS21059L08 | NUTPLATE |

NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE
 PRIOR TO INSTALLATION OF MS21059L08 NUTPLATES
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-042" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 1.00 lbs

| | | | |
|--|----------------|--|--------------|
| DESIGN | DE | DART AEROSPACE LTD | |
| DRAWN | DE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RSS | DRAWING NO. | REV. E |
| MFG. APPR. | NA | D3163 | SHEET 2 OF 4 |
| APPROVED | NA | TITLE | SCALE |
| DE APPR. | NA | PLATE | NTS |
| DATE | 09.10.21 | COPYRIGHT © 2002 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/4, REF DART SPEC. M2024T3S.032
OR 6061-T6 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/11, REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-3" USING REMOVABLE TAG
- 7) WEIGHT: 0.15 lbs

WLO
57752

RELEASED
2009-11-09
MP

| | | | |
|------------|----------|--|--------------|
| DESIGN | JS | DART AEROSPACE LTD | |
| DRAWN | JS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JS | DRAWING NO. | REV. E |
| MFG. APPR. | JS | D3163 | SHEET 4 OF 4 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | PLATE | NTS |
| DATE | 09.10.21 | <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |